

Split

Date: Friday, 22/05/2009 8:58:42 AM
User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STRUT		
Job Number	48108 - 1			Part Number	D2562001		
Estimate Number	10272			Drawing Number	D2562 REV D		
P.O. Number				Project Number	N/A		
This Issue	22/05/2009	S.O. No.	:	Drawing Revision	D		
Prsht Rev.	NC			Material			
First Issue	11	Type	SMALL /MED FAB	Due Date	28/05/2009	Qty:	40
Previous Run	42101			Um:	Each		
Written By							
Checked & Approved By	JL 09/05/2009						
Comment	Est F 02.04.15 Added dwg Rev.B1 NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	(7X)
		Comment: Qty.: 1.7920 f(s)/Unit Total : 17.9204 f(s) 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall Batch M 111097	m.l 09/06/02
2.0	BRAKE NC	NC BRAKE	(7X)
		Comment: NC BRAKE Punch to length as per Dwg D2562	m.l 09/06/02
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	(7X)
		Comment: SMALL/MED FAB RESOURCE 1- Bend end as per Dwg D2562 Angle "D" 2-Deburr	7 m.b 09/06/02
4.0	QC5	INSPECT WORK TO CURRENT STEP	(7X)
		Comment: INSPECT WORK TO CURRENT STEP	(09/06/02) (7X)
5.0	POWDER COATING	POWDER COATING	(7X)
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	M 111472
	START TIME:	8:30AM	
	OVEN TEMPERATURE:	400°F	
	FINISH TIME:	9:00AM	9/1 09-06-10 (7X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 48108

Part Number: D2562001

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

(A)

Comment: INSPECT POWDER COAT

FZ 09/06/10

7.0 PACKAGING 1



PACKAGING RESOURCE #1

(B)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 164

glv/10

SO

8.0 QC21



FINAL INSPECTION/W/O RELEASE



09/06/10 (C)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-0610

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

FOR INSTALLATION INSTRUCTIONS/REQUIREMENTS AND TECHNICAL INFORMATION SEE APPLICABLE
DART INSTALLATION INSTRUCTIONS.

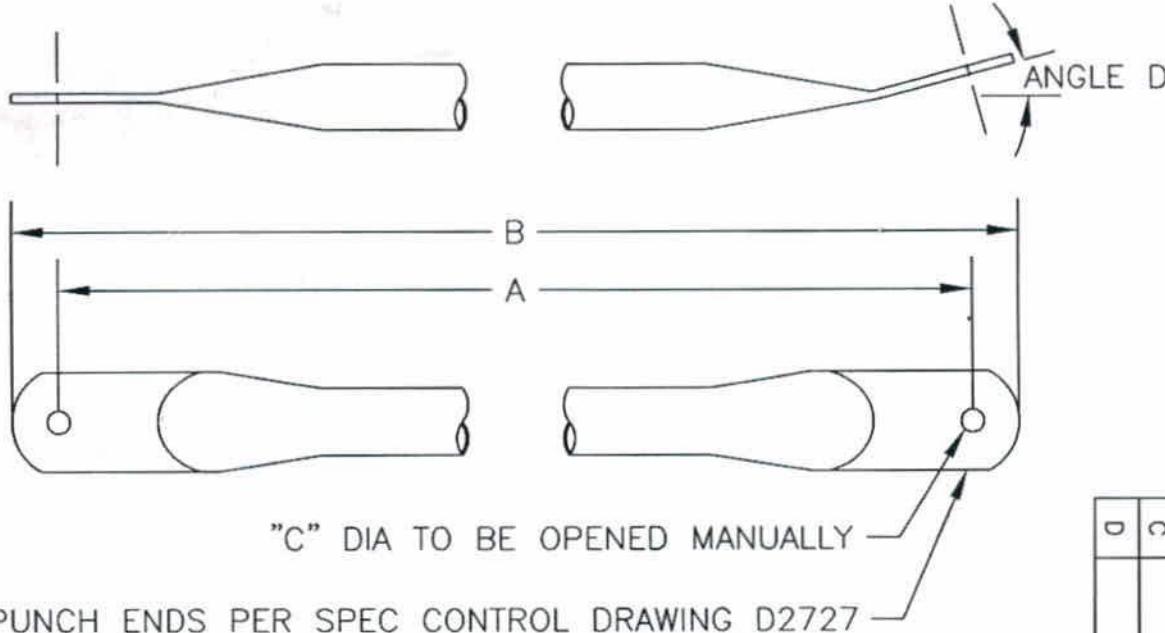
QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D206-648-011	GROUND HANDLING KIT
	X	D206-648-013	GROUND HANDLING KIT
8	8	D2652	BUSHING
2		D2659	GHW LUG
	2	D3414-041	LUG ASSEMBLY
4		AN3-37A	BOLT
	4	AN3C37A	BOLT
	4	AN960C10	WASHER
4		AN960JD10	WASHER
4		MS21042-3	NUT (OR MS21042L3)
	4	MS21043-3	NUT

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NO 48107

B	INSTALLATION AND WEIGHT AND BALANCE INFORMATION TRANSFERRED TO DART INSTALLATION INSTRUCTIONS D206-642. ALL HARDWARE UPDATED TO SS HARDWARE.			AJS	08.09.24
A	NEW ISSUE			JB	97.11.03
REV.	DESCRIPTION			BY	DATE
DESIGN	JB	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.			REV. B
MFG. APPR.	N/A	D206-648			SHEET 1 OF 1
APPROVED		TITLE			SCALE
DE APPR.		GND HANDLING WHEEL (GHW) INSTL			NONE
DATE	08.09.24	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

DART

DESIGN CP	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2562	REV. D SHEET 1 OF 1
DATE 05.05.18	TITLE STRUT	SCALE 1:12	
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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